

Work Order ID 89455-2

89455

Page 1

August 23, 2012 8:15:05 AM

Item ID: D3628-5

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cupped Washer

Start Date: 8/23/12

Start Qty: 4,000.00

4000

Cust Item ID:

Required Date: 9/10/12

Req'd Qty: 4,000.00

4000

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 12/8/22

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool -

Part
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3628

C

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

17738

Manufacture as per dwg D3628

Possible Supplier: GFI

Material release note is required

CL 12/08/23 4000

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

42/10/13 1393

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

Work Order ID 89455

August 23, 2012 8:15:05 AM

89455

Page 2

Item ID: D3628-5 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cupped Washer
 Start Date: 8/23/12 Start Qty: 4,000.00 *4000* Cust Item ID:
 Required Date: 9/10/12 Req'd Qty: 4,000.00 *4000* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
16
2-0

17/10/04

+1393

Q2 pag

12/10/14 (1393)

12/10/15

MF
12-10-5

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

Picklist Print

August 23, 2012 8:15:04 AM

Page 1

Work Order ID: 89455

Parent Item: D3628-5

Parent Item Name: Cupped Washer

Start Date: 8/23/12

Required Date: 9/10/12

Start Qty: 4,000.00

Required Qty: 4,000.00

Comments: IPP REV:A 12.04.24 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3628-5P CUPPED WASHER		Purchased	No			110	Each	0.0000	1	4000			

42/143 1393

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

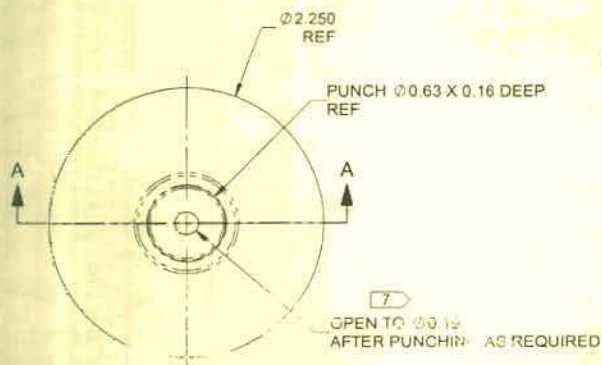
Work Order: _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

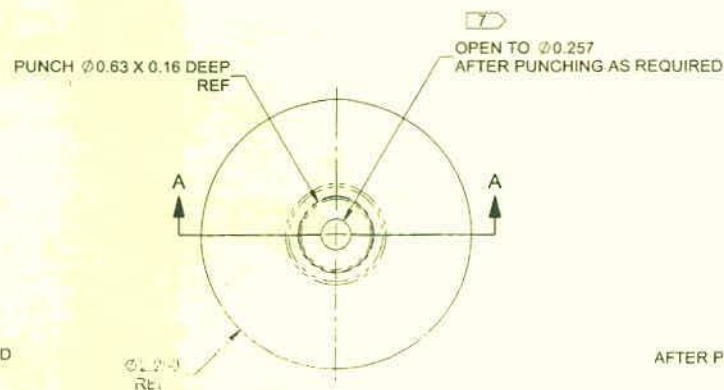
FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect
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<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong
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<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Pressure/Force
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

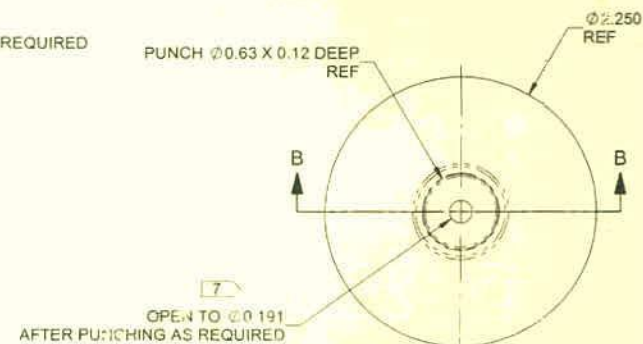
C&12/08/22



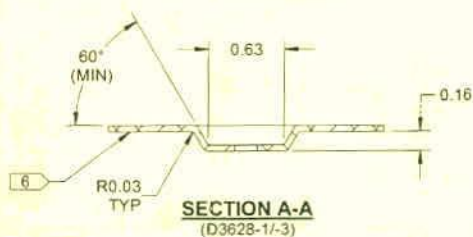
D3628-1 CUPPED WASHER



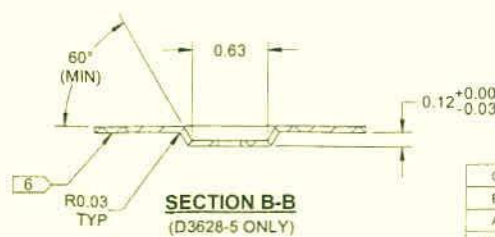
D3628-3 CUPPED WASHER



D3628-5 CUPPED WASHER



SECTION A-A
(D3628-1/-3)



SECTION B-B
(D3628-5 ONLY)

- NOTES:
- 1) MATERIAL: MADE FROM D3628-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.5
 - 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA WITHIN 0.03
 - 8) WEIGHT: 0.02 lbs

RELEASE
2012-05-07

REV	DESCRIPTION	BY	DATE
C	UPDATE DWG TO CURRENT STD, ADD -5, ZN C1-1.	DC	12.04.19
B	REMOVE POWDER COAT	CB	07.07.09
A	NEW ISSUE	CB	07.06.08
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	ES	DRAWING NO.	REV. C
MFG. APPR.	FE	D3628	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR	HA	CUPPED WASHER	NTS
DATE	12.04.19	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR COMPANY WITHOUT PERMISSION FROM DART AEROSPACE LTD</small>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

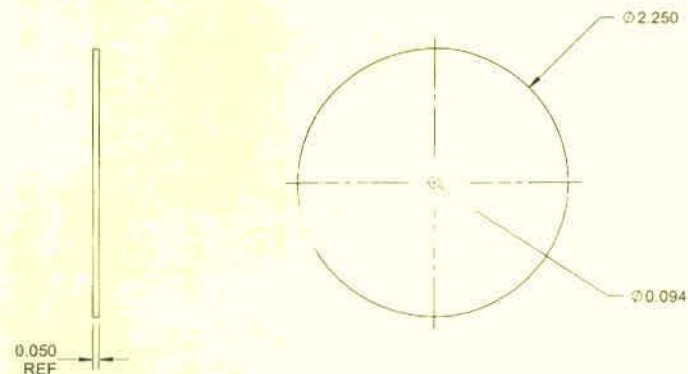
QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain:	<input type="checkbox"/> Ovalized
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance
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<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other



D3628-1F FLAT PATTERN

RELEASED
2012-05-07

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
ANNEALED, 2B FINISH
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	EB	DRAWING NO.	REV. C
MFG. APPR.	EB	D3628	SHEET 2 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	HA	CUPPED WASHER	NTS
DATE	12.04.19	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
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Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO	PAGE
JR - DY	MO - MO	AN - YR		
02	10	12	0498281	1/1



VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE	N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR / SHIP VIA
DART	GFI-0299	0255796	PO17738

QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.	DESCRIPTION
1393	D3628-5P	CUPPED WASHER

MFG. JOB# J0255796 - 001 QTY 1393 pcs
DUE DATE: 14 September 2012



REÇU PAR / RECEIVED BY

DATE

EXPÉDITEUR / SHIPPER	N° DE BON DE LIVRAISON / SHIPPING MEMO NO
----------------------	---



TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CÉRTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	3	OUR JOB NO	J0255796	SHIPPING MEMO	0498281	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
—	1393 PCS	PO17738	D3628-5P	C	CUPPED WASHER	C
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
AMS 5513 304 ANN		TW METALS / ALLEGHENY LUDLUM		H/N 837666		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	N/A
2	REF. GFI MANUFACTURING JOB NUMBER J0255796-001 (1393 PCS)	GFI	N/A
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 01 OCTOBER 2012

G.F.I. Q.C. REP.

Albert Harold
GFI
QUALITY
0001



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17989

Purchase Order Date 9/25/12

PO Print Date 9/25/12

Page Number 1 of 1

Order From :

VC-GEO001

GEORGE WADSWORTH & ASSOCIATES
5-129 MAIN STREET
HAWKESBURY, ONT K6A 1A1
CA

Contact Name

Vendor Phone

514 894 3492

Vendor Fax

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 15

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
(513) 632 1053

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1		DELL PRECISION M4700 LAP TOP	10/05/12 Yes	1.00 Each	Yours ppd	\$3,795.0000	\$3,795.00

Deliver To: MIKE P

PO Total:

\$3,795.00

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES

NO

Change Nbr: 1

Change Date: 9/25/12

1875



**Dart Aerospace
Capital Asset Request Form**

Asset Name	Dell laptop
Request Date:	25-Sep-12
Estimated Purchase Date	25-Sep-12
Estimated Date for Use of Asset	5-Oct-12
Department:	Eng - 90

Asset Type	
<input type="checkbox"/>	Construction In Progress
<input type="checkbox"/>	Capital lease
<input checked="" type="checkbox"/>	Capital Asset

Brief Description of Asset

Dell Precision M4700	MS Office H&B with Adobe X
Intel i7 3820M 2.7Ghz	Dell E dock
16Gb ram	Dual Dell P series 23" monitors
256Gb SSD hard drive	Dell 3 Year NBD onsite warranty
DVD/RW	
Intel centrino advanced N	
Dell Bluetooth	
Win 7 Pro 64	

Capital Cost (Excluding Taxes)	\$3,795	<input type="checkbox"/> USD <input checked="" type="checkbox"/> CAD
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Pay-Back Period - Net Present Value

Estimated Savings

Requested By Mike Petsche

Approved By:

 12/09/25.



METALS
O'Neal High-Performance
Metals Group

CERTIFICATIONS

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious or fraudulent statements or entries on this document may be punished as a felony under statutes including federal law. Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

TW Metals certifies that the supplies furnished under this contract contain no metallic mercury or mercury compounds, and have not come in contact with mercury or alpha bearing instruments while in the possession of TW Metals Inc.

Customer Name: GFI, Inc

Purchase Order No.: 0081162

Item number: 0001

Shipper/Invoice No.: 03300298

Material: 304
S/S sheet

Manufacturing Mill: United Performance

Specification: Ams 5573

Heat / Lot No. 837666

Size: .050

Quantity: 8 pcs

Signature: Janice Clark

Date: 9/13/12

NOTICE OF SHIPMENT/
PACKING LIST



CERTIFICATE OF TEST

AL 6169-4 1211

CUST. ORD. NO. & DATE: 01020865
 CUST. CODE: 05/17/12 110977
 VENDOR: VANDERGRIFF, PA.
 SHIPPER NO: 545003
 PRODUCT CODE: 13020102060000
 MILL ORDER NUMBER: 30-052-366
 DATE SHIPPED: 07/03/12
 SOLD TO: UNITED PERFORMANCE METALS
 3475 SYMMES ROAD
 HAMILTON OH 45015
 SHIP TO: UNITED PERFORMANCE METALS
 3475 SYMMES ROAD
 HAMILTON OH 45015

GRADE AND SPECIFICATIONS: "ATI 304L" STAINLESS STEEL SHEET C R COILS ANNEALED 2B FIN 3 EDGE (UPM 304L/304/302 LCS) (AMS 2248G) (AMS 5511H) (AMS 5513J) (AMS 5516P) (ASTM-A-262-10 PRA E/SCREEN PRA A) (ASTM-A-666-10) (S-400 DTD 10/10/2011) (ASTM-A-240-12) (S-1000 DATED 8/1/2011) (ASME-SA-240 ED 2010) (10/11/10 EXCEPT UPM 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (UPM-QRS-001) (EN 10028-7:2007-1.4301-2B) (EN 10028-7:2007-1.4307-2B) (PWA 300 REV BK) (F-14, F-17, F-22, F-23, F-MASTER) (CONTROLLED TO PWA LCS REQUIREMENTS)

ITEM	PCS	DIMENSIONS W/G/L	HEAT #	COIL #	TEST #	GROSS	TARE	NET	THEO	TAG #/	CD	SKID #
001	1	36./050/2507.	837666	05242N093	8794397	15650	50	15600		872978		
		C CUST IDENTITY 00636										
		1 SKID										

TYPE HEAT/TEST	HEAT	TEST LOCATION	CHECK	TEST LOCATION	YIELD	TENSILE	% ELONG	HARDNESS	BEND	A 262	PR E	SIZE
HEAT 837666	837666	8794397	8794397	8794397	45500.	95000.	75.	82.HRBW	T PASS	PASS		7.
TEST LOCATION	TC	TC	TC	TC	TC	TC	TC	TC	TC	TC	TC	TC

ITEM TEST NO	TEST LOCATION	YIELD	TENSILE	% ELONG	HARDNESS	BEND	A 262	PR E	SIZE
001 8794397	TC	45500.	95000.	75.	82.HRBW	T PASS	PASS		7.
TEST LOCATION	TC	TC	TC	TC	TC	TC	TC	TC	TC

ITEM TEST NO	TEST LOCATION	CORROSION	MELT	T-YIELD	P&W E-25	TRAN BEND
001 8794397	TC	ISO 3651-2	SOURCE	1%	2.	
TEST LOCATION	TC	PASS	1.	52500.		

TW METALS
 149280492
 JUL 23 2012
 ACCEPTED BY
 [Signature]

REVIEWED BY Q.C.

Date: 7/4/12 By: [Signature]

PAGE 01 - CONTINUED ON PAGE 02

CONSIGNMENT: Please Note - This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on receipt before signing.

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-226-5980. CAUTION: Processing that makes fumes, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

WARNING: Les fiches d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des exemplaires supplémentaires veuillez téléphoner au numéro suivant 724-226-5980. Attention: les traitements entraînant la production de vapeurs, poussières, ou solutions peuvent être cause de maladies pulmonaires. Pour plus de renseignements se référer aux fiches d'information sécurité.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgment.

Stephen Wolf
 Director, Corporate Quality Assurance

Description: 304L, ANN 046-052 AMS551.1, 5511
 Customer: TW Metals
 Shipped: 07/02/2012
 Heat: 837666
 Size: 36 X 120
 P.O.: 149280492
 Part: 51073
 Sales: 01191693
 Quantity: 16

UNITED PERFORMANCE METALS
 This is to certify that in accordance with the record in our files the material shipped on your purchase order conforms to the following:
 3475 Symmes Road Hamilton, OH 45015

Authorized Signature:
 [Signature]
 Lynne Harper

NOTICE OF SHIPMENT/
PACKING LIST



CERTIFICATE OF TEST

AL 6168-4 1211

CUST. ORD. NO & DATE 01020865		CUST. CODE 05/17/12 110977	ACCEPTING MILL VANDERGRIFT, PA.	SHIPPER NO. 545003	PRODUCT CODE 13020102060000	MILL ORDER NUMBER 30-052-366	DATE SHIPPED 07/03/12
FORMS DISTRIBUTION SOLD TO 1 SHIP TO 57C		REPEAT ORDER 82037-5	DO RATE 26	GOVT CONTRACT	MATL. 1124	SHIPPING LOCATION VANDERGRIFT PA	INVOICE 655648
SOLD TO UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015		PRIME SEC. DSO DSO 516	SHIP TO UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015				

GRADE AND SPECIFICATIONS CARRIER - GROSS, RONALD, INC.
 "ATI 304L" STAINLESS STEEL SHEET C R COILS ANNEALED 2B FIN 3 EDGE (UPM 304L/304/302 LCS) (AMS 2248G) (AMS 5511H) (AMS 5513J) (AMS 5516P) (ASTM-A-262-10 PRA E/SCREEN PRA A) (ASTM-A-666-10) (S-400 DTD 10/10/2011) (ASTM-A-240-12) (S-1000 DATED 8/1/2011) (ASME-SA-240 ED 2010) (10/11/10 EXCEPT UPM 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (UPM-QRS-001) (EN 10028-7:2007-1.4301-2B) (EN 10028-7:2007-1.4307-2B) (PWA 300 REV BK) (F-14, F-17, F-22, F-23, F-MASTER) (CONTROLLED TO PWA LCS REQUIRMENTS)

ITEM	PCS	DIMENSIONS W/G/L	HEAT #	COIL #	TEST #	GROSS	TARE	NET	THEO	TAG #/	CD	SKID #
001	1	36./ .050/2507.	837666	05242N093	8794397	15650	50	15600		872978		
		C CUST IDENTITY 00636										
		1 SKID				15650	50	15600				

TYPE HEAT/TEST	--C--	--MN--	--P--	--S--	--SI--	--CR--	--NI--	--MO--	--CU--	--N--
HEAT 837666	.021	1.75	.033	.0001	.35	18.22	8.09	.32	.45	.08
TEST LOCATION	BN	BN	BN	BN	BN	BN	BN	BN	BN	BN
CHECK 8794397	.023	1.77	.033	.0002	.35	18.19	8.06	.32	.45	.07
TEST LOCATION	TC	TC	TC	TC	TC	TC	TC	TC	TC	TC
ITEM TEST NO	YIELD PSI *	TENSILE PSI	% ELONG IN 2"	% R/A	HARDNESS	BEND	A 262 PR E	SIZE	CORROSION	GRAIN
001 8794397	T 45500.	95000.	75.		82.HRBW	T PASS	PASS	7.		
TEST LOCATION	TC	TC	TC		82.HRBW	TC	TC	TC		
	* Y.S. BY 0.2% OFFSET METHOD									
ITEM TEST NO	CORROSION	MELT	T-YIELD	P&W E-25						
001 8794397	ISO 3651-2	SOURCE	1%	TRAN BEND						
TEST LOCATION	PASS	1.	52500.	2.						
	TC		TC	TC						

TW METALS
 1449280492
 JUL 23 2012
 ACCEPTED BY
 [Signature]

REVIEWED BY Q.C.
 Date 7/4/12 By [Signature]

PAGE 01 - CONTINUED ON PAGE 02

CONSIGNEE: Please Note-This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on waybill before signing.

WARNING: Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-226-5980. CAUTION: Processing that involves heat, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

Les fiches d'information-sécurité de ce produit ont été fournies à votre département chargé des achats. Pour obtenir des exemplaires supplémentaires veuillez téléphoner au numéro suivant 724-226-5980. Attention: les traitements entraînant la production de vapeurs, poussières, ou solutions peuvent être cause de maladies pulmonaires. Pour plus de renseignements se référer aux fiches d'information-sécurité.

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgement.

07/03/12 15:45:13
 Stephen Wolf - Director, Corporate Quality Assurance

Description: 304/304L ANN 048-052 AMS5513.5511
 Customer: TW METALS
 Shipped: 07/03/12
 Heat: 837666

Size: 36 X 120
 P.O.: 144292892
 Part: 51073
 Sales #: 01191693
 Quantity: 16

UNITED PERFORMANCE METALS
 This is to certify that in accordance with the records in our files the material shipped on your purchase order conforms to the following:
 3475 Symmes Road Hamilton, OH 45015

Authorized Signature
 Lynne Harper

NOTICE OF SHIPMENT/
PACKING LIST



CERTIFICATE OF TEST

AL 6168-4 1211

CUST. ORD. NO. & DATE 01020865 FORWAS DISTRIBUTION		CUST. CODE 05/17/12 110977	VANDERGRIFT, PA.	SHIPPER NO. 545003	PRODUCT CODE 13020102060000	MILL ORDER NUMBER 30-052-366	DATE SHIPPED 07/03/12
SOLD TO UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015	REPEAT ORDER 82037-5	DO DATE 26	PRIME SEC. DSO DSO 516	GOVT CONTRACT	MATL 1124 VANDERGRIFT	SHIPPING LOCATION PA	INVOICE 655648
				SHIP TO UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015			

GRADE AND SPECIFICATIONS
"ATI 304L" STAINLESS STEEL SHEET C R COILS ANNEALED 2B FIN 3 EDGE (UPM 304L/304/302 LCS) (AMS 2248G) (AMS 5511H) (AMS 5513J) (AMS 5516P) (ASTM-A-262-10 PRA E/SCREEN PRA A) (ASTM-A-666-10) (S-400 DTD 10/10/2011) (ASTM-A-240-12) (S-1000 DATED 8/1/2011) (ASME-SA-240 ED 2010) (10/11/10 EXCEPT UPM 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (UPM-QRS-001) (EN 10028-7:2007-1.4301-2B) (EN 10028-7:2007-1.4307-2B) (PWA 300 REV BK) (F-14, F-17, F-22, F-23, F-MASTER) (CONTROLLED TO PWA LCS REQUIREMENTS)

THIS DIN EN 10204:2005 - 3.1 CERTIFICATE OF TEST SHALL NOT BE REPRODUCED EXCEPT IN FULL. FEDERAL LAW PROHIBITS THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE AND MAY BE PUNISHABLE AS A FELONY UNDER FEDERAL LAW. ATI AL HOLDS SEVERAL QUALITY CERTIFICATIONS THAT INCLUDE ISO-9001, AS9100, NADCAP, AND ISO/IEC 17025. MATERIAL WAS MANUFACTURED IN ACCORDANCE WITH THE ATI AL QUALITY MANUAL REVISION 20 DATED 02/24/2012.

ATI ALLEGHENY LUDLUM WORKS TO THE ROLLS ROYCE SABRE QUALITY MANAGEMENT SYSTEM.

QUALITY SYSTEM CERTIFIED ACCORDING TO PRESSURE EQUIPMENT DIRECTIVE 97/23/EC, ANNEX I, 4.3 BY TUV SUD, INDUSTRIE SERVICE GMBH, (NOTIFIED BODY 0036).

ATI ALLEGHENY LUDLUM PERFORMS CHEMICAL ANALYSIS BY THE FOLLOWING TECHNIQUES:
C, S BY COMBUSTION/INFRARED
N, O, H BY INERT FUSION/THERMAL CONDUCTIVITY
MN, P, SI, CR, NI, MO, CU, CB, CO, V BY WDXRF
B BY OES
AL AND TI (>=0.10%) BY WDXRF, OTHERWISE BY OES
PB, BI, AG BY GFAA

MATERIAL TESTED AT ATI ALLEGHENY LUDLUM GEAE S400 APPROVED FACILITIES (T1225 & T9317):
NATRONA HEIGHTS, PA TECHNICAL CENTER; BRACKENRIDGE, PA AND NEW BEDFORD, MA.

TW METALS	
M49280492	R
JUL 23 2012	P
ACCEPTED BY	S

PAGE 03 - CONTINUED ON PAGE 04

CONSIGNEE- Please Note- This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on invoice before signing.

Material Safety Data Sheets for this product have been supplied to your Purchasing Department. For an additional copy phone 724-726-5980. CAUTION: Processing that makes fumes, dust, or solutions may cause lung disease. See Material Safety Data Sheets for further information.

WARNING

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07/03/12 15:45:13

The above is a true copy of data on file. The material and test results conform to the sales contract and specification(s) as set forth in Allegheny Ludlum's Order Acknowledgement.

Shafiqul Wadai
Director, Corporate Quality Assurance

Description: 304L AIN 048-052 AMSS5113511
Customer: TW Metals
Shipped: 07/20/12
Lot: 837666

Size: 36 X 120
P.O.: M49280492
Part#: 51073
Sales #: 01919603
Quantity: 16

UNITED PERFORMANCE METALS
This is to certify that in accordance with the records in our files the material shipped on your purchase order conforms to the following:
3475 Symmes Road Hamilton, OH 45015

Authorized Signature
Lynne Harper

NOTICE OF SHIPMENT/
PACKING LIST



CERTIFICATE OF TEST

AL 6168-4 1211

CUST. ORD NO & DATE 01020865		CUST. CODE 05/17/12 110977	SHIPPER NO VANDERGRIFF, PA. 545003	PRODUCT CODE 13020102060000	MILL ORDER NUMBER 30-052-366	DATE SHIPPED 07/03/12
FORMS DISTRIBUTION SOLD TO UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015		REPEAT ORDER 82037-5	DO DATE PRI 126	MATL 1124 VANDERGRIFF	SHIPPING LOCATION PA	INVOICE 655648
		PRIME SEC. DSO DSO 516	SHIP TO UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON OH 45015			

GRADE AND SPECIFICATIONS CARRIER - GROSS, RONALD, INC.
 "ATI 304L" STAINLESS STEEL SHEET C R COILS ANNEALED 2B FIN 3 EDGE (UPM 304L/304/302 LCS) (AMS 2248G) (AMS 5511H) (AMS 5513J) (AMS 5516P) (ASTM-A-262-10 PRA E/SCREEN PRA A) (ASTM-A-666-10) (S-400 DTD 10/10/2011) (ASTM-A-240-12) (S-1000 DATED 8/1/2011) (ASME-SA-240 ED 2010) (10/11/10 EXCEPT UPM 304L/304/302) (UNS S30403) (UNS S30200) (UNS S30400) (UPM-QRS-001) (EN 10028-7:2007-1.4301-2B) (EN 10028-7:2007-1.4307-2B) (PWA 300 REV BK) (F-14, F-17, F-22, F-23, F-MASTER) (CONTROLLED TO PWA LCS REQUIREMENTS)

ATI ALLEGHENY LUDLUM HOLDS SEVERAL QUALITY AND LABORATORY CERTIFICATIONS THAT INCLUDE ISO-9001, AS9100, AD 2000-MERKBLATT WO, EU PRESSURE EQUIPMENT DIRECTIVE 97/23/EC, NADCAP, ISO/EIC 17025, GEAE S400, GEAE S-1000. REFER TO WWW.ALLEGHENYLUDLUM.COM TO ACCESS THE CURRENT ATI AL QUALITY CERTIFICATIONS.

THE NUMERIC CODES SHOWN UNDER MELT SOURCE CAN BE INTERPRETED AS FOLLOWS:
 1. - MATERIAL MELTED, ROLLED AND TESTED IN THE UNITED STATES.
 2. - FOREIGN MELT; ROLLED AND TESTED IN THE UNITED STATES.

TESTING WAS PERFORMED AT THE FOLLOWING LOCATIONS:
 BN = ATI-ALLEGHENY LUDLUM; 100 RIVER ROAD; BRACKENRIDGE, PA 15014
 TC = ATI-ALLEGHENY LUDLUM; 1300 PACIFIC AVENUE; NATRONA HEIGHTS, PA 15065

TW METALS	
M49280492	REPORTS
JUL 23 2012	
ACCEPTED BY	

PAGE 04 - FINAL PAGE.

ISSUED BY ATI ALLEGHENY LUDLUM - 07/05/2012 07:45
 CARRIE MCFALL - QUALITY ASSURANCE DEPT.

CONSIGNEE: Please Note - This consignment was turned over to carrier in first class condition, being correctly loaded, at which time our responsibility for loss or damage in shipment ceased. For your protection please examine shipment as it arrives. If any shortage or damage is discovered, have a full description made by transportation agent on waybill before signing.

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Sigchen Wolf - Director, Corporate Quality Assurance

Description: 304/204L ANN 048-052 AMS5511 5511
 Customer: TW Metals
 Shipped: 07/20/2012
 Heat: 837008

Size: 36 X 120
 P.O.: M49280492
 Part: 51073
 Sales #: 01191693
 Quantity: 16

UNITED PERFORMANCE METALS
 This is to certify that in accordance with the records in our files the material shipped on your purchase order conforms to the following:
 3475 Symmes Road Hamilton, OH 45015

Authorized Signature
 Lynne Harper

